

Rush

Work Order ID 63246

Tuesday, October 26, 2010 10:17:18 AM



X

Page 1

Item ID:	D3201-4	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	10/26/2010	Start Qty:	20.00			
Required Date:	10/29/2010	Req'd Qty:	20.00			
Reference:						
Cust Item ID:						
Customer:						

Approvals:	Process Plan:	<u>AL</u>	Date:	<u>10/10/26</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3201	Rev B								

100	0.00								
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3201	<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-					
5624 .050	Deburr if necessary								

RB10-10-26

Signature: 10/10/26

(24)

110	0.00								
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

RB10-10-26

120	0.00								
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Signature: 10/10/26

(x24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3201-4

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Setup Start

Revision ID:

Stop

Item Name: Doubler

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Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Debur Stack

ES 10/10/26 (24)

140



Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

1-Bend as per Dwg D3201
dwg D3201

□ 2-Scribe part# and Batch# per

u/28

ES 10/10/27

(24)

Plz →

150



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

8 10/10/27

(x24
-4)

Dart Aerospace Ltd

W/O: 63246		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/27 S	10 HO	Remove to describe P# + Batch # no longer required	PA	10-10-29			S 10/10/27	

Part No: D3201-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Stop



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Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ 10/10/27

24

Ø

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

BR 10-10-27

24.

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: 41

0.00

10/10/27 (24x)

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Page 4

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 *[Signature]*

H 10-10-28

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:17:22 AM

Page 1

Work Order ID: 63246



Parent Item: D3201-4



Parent Item Name: Doubler

Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM
IPP Rev:B Now on Waterjet 06-08-14 JLM
IPP Rev :C Added scribing, NCR262 07.11.29 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

106.8847

0.045

0.947368



BIO-10-26

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

106.8847

111381

11.89

113189

0.3947

114968

94.6

114968

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

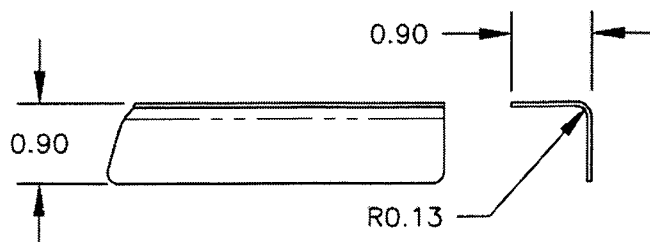
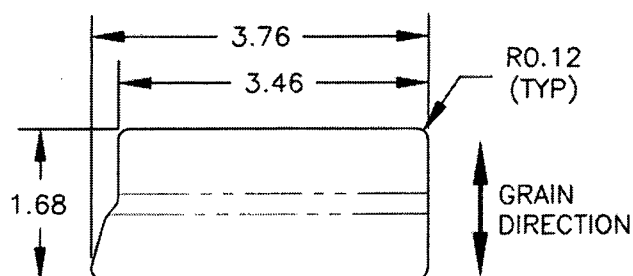
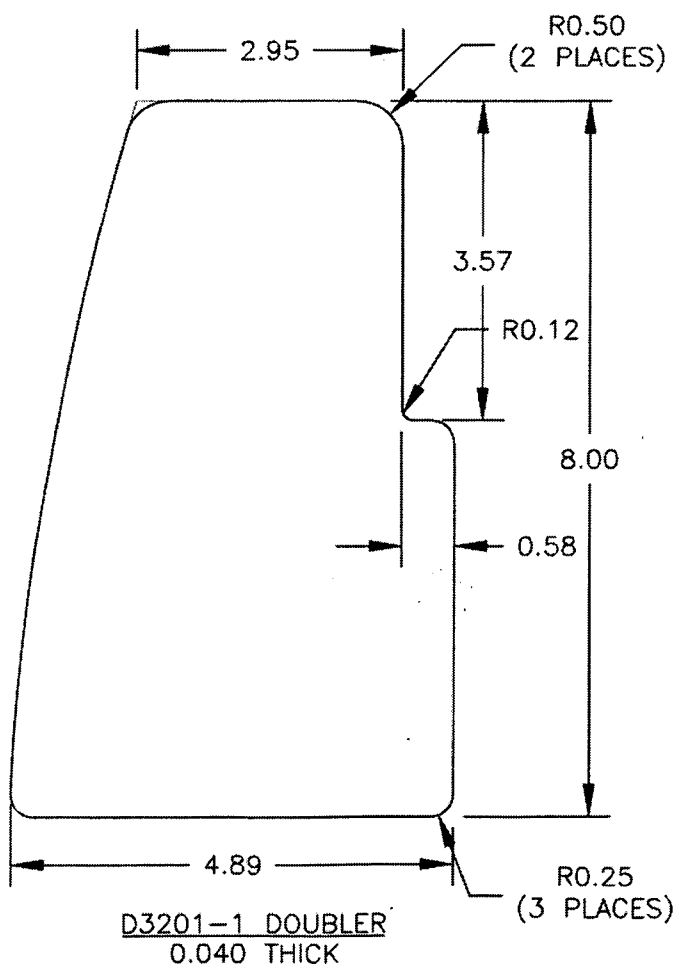
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DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3201	SHEET 1 OF 1
DATE	03.11.03	TITLE	DOUBLER	SCALE	1:2
A	03.08.07	NEW ISSUE			
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4			

RELEASED
03.11.14



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *03244*

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